

NCR 19-7640



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D4880-041

Job Sheet 196136



Part No: D4880-041

Job Qty: 1 pcs

Part Name: 206A/B FWD Leg Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/7/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/2/19

Description:

Type: SOLD

Note: DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV:C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	7/2/19		0.00	0.55	Small Fab - 1		Fixed 71 19-7-2
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	7/2/19		0.00	0.00	QC 5 - 10		Sms 19/7/12
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Small Fab - 2 - B4B	1 pcs	7/2/19		0.00	0.55	Small Fab - 1 - B4B		Fixed 71
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		

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140 QC 5	1 pcs	7/2/19	0.00 0.00	Small Fab - 7 - B4B				
				QC 5 - 10				
				QC 5 - 12				
				QC 5 - 17				
				QC 5 - 18				
				QC 5 - 19				
				QC 5 - 22				
				QC 5 - 24				
				QC 5 - 3				
				QC 5 - 43				
				QC 5 - 49				
				QC 5 - 51				
				QC 5 - 58				
				QC 5 - 68				
				QC 5 - 9				
				QC 5 - 50				
				QC 5 - 30				
				QC 5 - 40				
				180 Packaging 3-1 - Stock - B4B 1 pcs	7/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
Packaging 3 - 3 - B4B								
Packaging 3 - 4 - B4B								
Packaging 3 - 5 - B4B								
Packaging 3 - 6 - B4B								
Packaging 3 - 7 - B4B								
Packaging 3 - 8 - B4B								
Packaging 3 - 9 - B4B								
Packaging 3 - 10 - B4B								
Packaging 3 - 11 - B4B								
Packaging 3 - 12 - B4B								
Packaging 3 - 13 - B4B								
Packaging 3 - 14 - B4B								
Packaging 3 - 15 - B4B								
Packaging 3 - 16 - B4B								
Packaging 3 - 17 - B4B								
Packaging 3 - 18 - B4B								
Packaging 3 - 19 - B4B								
Packaging 3 - 20 - B4B								
Packaging 3 - 21 - B4B								
Packaging 3 - 22 - B4B								
Packaging 3 - 23 - B4B								
Packaging 3 - 24 - B4B								
Packaging 3 - 25 - B4B								
Packaging 3 - 26 - B4B								
Packaging 3 - 27 - B4B								
Packaging 3 - 28 - B4B								
Packaging 3 - 29 - B4B								
Packaging 3 - 30 - B4B								
Packaging 3 - 31 - B4B								
Packaging 3 - 32 - B4B								
Packaging 3 - 33 - B4B								
Packaging 3 - 34 - B4B								
Packaging 3 - 35 - B4B								
Packaging 3 - 36 - B4B								
190 QC 21 - SA	1 pcs	7/2/19	0.00 0.00	QC 21 - SA - 21				
				QC 21 - SA - 70				
				QC 21 - SA - 53				

DAS
40
JUL 03 2019 9-89

PC STSIS



Part Op 110 - Small Fab - ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 AND D4884-1. DRILL OUT EACH
Descriptions: HOLES USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP

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PC STSIS



DT9971 AS PER DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Small Fab 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE

DT9971 A/R HYSOL BATCH: S126610 2- LASER ENGRAVE PART# AND SERIAL # AS PER DWG

140 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____

190 - Identify as per dwg & Stock Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4880-1	Strut	1 pcs (1 ea)	110-Small Fab - 1	S128474
D4883-7	End Fitting	1 pcs (1 ea)	110-Small Fab - 1	S118087
D4884-1	End Fitting, Eye	1 pcs (1 ea)	110-Small Fab - 1	S140145
HL32PB5-12	Hi-Lok Pin	4 Ea (4 ea)	110-Small Fab - 1	S126902
HL86-5	Hi-Lok Collar	4 pcs (4 ea)	110-Small Fab - 1	S131220
				S163223

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4880-1	1	6	0
	D4883-7	1	4	0
	D4884-1	1	3	0
	HL32PB5-12	4	39	0
	HL86-5	4	100	0

Part Specifications

Specifications could not be found.

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QSI 044 6.8

Entered: JEDate: Oct 28/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7640Route update only ☐

Job: <u>196136</u> Part No. <u>04880-1</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date: <u>JUL 05 2019</u>		Sequence #: <u>140</u>		QTY Affected: <u>1 of 1</u>		MRB (QS1042) DAS 55 9-89																											
Description Work Order Deviation				Disposition		Completed By: <u>DAS 40</u> <u>JUL 05 2019 9-89</u> Lead hand / Supervisor <u>N/A MPD</u> QC / QA Coordinator DAS 55 9-89 <u>JUL 5th 2019</u>																											
<u>-marks and grooves on tube</u>				<u>-scrap no replace</u>																													
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☒ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>				☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☒ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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		Other/Details:																															